



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB6897875
Job Sheet 168853



Part No: RB6897875

Job Qty: 6 ea

Part Name: Fuel Nozzle Holding Fixture



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 12/21/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Air Methods Corporation (CAMET01)

7301 South Peoria Street Englewood, CO, 80112 USA ph:(303) 792-7400

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/20/17	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	6 pcs		12/21/17	0.00	1.00	Small Fab-9		MCC DAS
110	QC	6 pcs		12/21/17	0.00	0.00	QC5		38
120	Packaging	6 pcs		12/21/17	0.00	0.00	Packaging3-2		2018-07-3
130	QC21-SA	6 Ea		12/21/17	0.00	0.00	QC21		GA

Part Op Descriptions: 100 - ASSEMBLE AS PER DWG

DAS 21 9-89 JUL 03 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	48725303 18	6	0	0	0 5033914
	91255A273 69	6	0	0	0 5016995
	RB6897875-1 74	6	0	0	0
	RB6897875-2 139	6	0	0	0 5033081

Part Specifications

Specifications could not be found.

Plex 11/23/17 1:43 PM Dart.lajeunesse.marie

1-5054494

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved		☐ Skid-tu ☐ Machin ☐ Thermoform ☐ Large f	Date : _____ Step #: _____ QTY Ef _____	Description Work Order Deviation _____ _____		Root Cause <table border="1"><tr><td>☐ No Re-verification</td><td>☐ Operator</td><td>☐ Offset/Setup</td><td>☐ Supplier</td><td>☐ Training</td><td>☐ Use for Testing</td><td>☐ Poor Information</td><td>☐ Rushing</td><td>☐ Product Improvement</td><td>☐ Process Improvement</td><td>☐ Manufacturing Process</td><td>☐ Past Due</td></tr></table>		☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	<table border="1"><tr><td>☐ Environment</td><td>☐ Design</td><td>☐ Doc/Data</td><td>☐ Equip/Tooling</td><td>☐ Handling/Pre</td><td>☐ Material</td><td>☐ Internal Transport</td><td>☐ Tribal Knowledge</td><td>☐ LOA</td><td>☐ Substation</td><td>☐ Past Expiry Date</td><td>☐ Misidentified</td></tr></table>		☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified
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DART
AEROSPACE

Container No: S083103

Part: RB6897875

Job No: 168853

Serial No/Batch: S083103

Revision: 3 U/R

Inspector:

Exp Date:

Instructions:

Date: 06/21/18

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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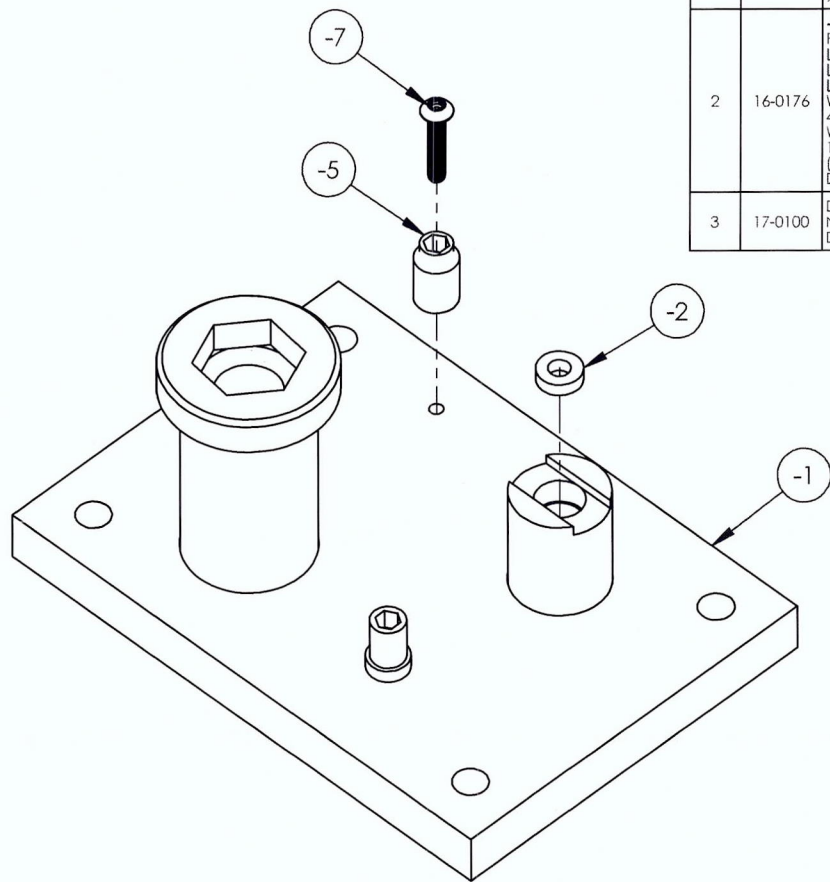
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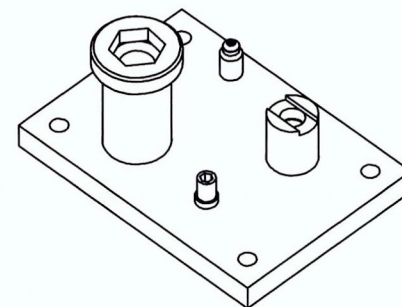
AGAINST DEPARTMENT/PROCESS

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-9 ADDED, -7 ADDED P/N TO BOM. -1 ADDED WELDMENT. -1A CHD DIA. WAS Ø.780 IS Ø.880 THRU. CHD DIA. WAS Ø1.500 IS Ø1.500-1.501 ∇ . 18. CHD DIA. WAS Ø1.50 IS Ø.180. CHD DIA. WAS Ø.475 IS Ø.500+.005/-0.000 CHD DIA. WAS Ø1.125 IS Ø1.124 ∇ . 18. ADDED Ø.125+.001-.000 ∇ . 55 HOLE FOR -9. -1B CHD DIA. WAS .880 IS .780. ADDED MISSING. 12 DIM. FOR 35° ANGLE. ADDED REF. DIM. Ø1.123. -1C CHD MATERIAL WAS 01 IS 4140. -1D CHD OD WAS Ø1.125 IS Ø1.124-1.125, ADDED Ø.125+.001-.000 ∇ . 375 HOLE FOR -9. CHD MATERIAL WAS 01 IS 4140.	8/5/2013	RJC	GE
2	16-0176	P-1 CHD DWG. TO SHEET METAL TOLERANCES, ADDED FINISH SPEC. QMSI-6.2.2, Ø.0. REV D. ADDED P/N -1A. -1A CHD MATERIAL WAS 1018 IS A36/1018/1020. CHD DIM WAS Ø.880 THRU ALL $\square$ Ø1.501/-1.500 ∇ . 18 IS Ø.880 THRU ALL $\square$ Ø1.514/-1.508 ∇ . 18, WAS Ø.375 THRU ALL $\square$ Ø.126/-1.125 ∇ . 18 IS Ø.375 THRU ALL $\square$ Ø1.139/-1.133 ∇ . 18, WAS Ø.180 THRU ALL $\square$ Ø.500+.005/-0.000 ∇ . 18 IS Ø.180 THRU ALL $\square$ Ø.50+.05/-0.00 ∇ . 18, WAS .4375 IS .438/.437, WAS Ø.125+.001/-0.000 IS Ø.1271/.1261, ADDED DIM 2.50. -1B, -1C, -1D CHD MATERIAL WAS 1018 IS 4140/4142, ADDED HEAT TREAT RC 28-32. -1C CHD DIM WAS Ø1.500 IS Ø1.500-1.496. -1C CHD DIM WAS [2.00] IS 2.00, WAS Ø1.500 ∇ . 120 IS Ø1.514/-1.508 ∇ . 12, WAS 1.082/-1.072 HEX IS 3X 1.082/.072. -1D CHD DIM WAS Ø1.125/-1.124 IS Ø1.125 IS Ø. ∇ . 12 CHD DIM WAS Ø.515 IS Ø. ∇ . 5150/-5143 (P.F. -2), WAS .438 IS .438/.437, WAS Ø.125+.001/-0.000 ∇ . 375 IS Ø.1271/.1261 ∇ . 38 (P.F. -9). -2 CHD DIM WAS Ø.515 IS Ø.515/-5155 (P.F. -1D). -5 CHD BO INFO WAS 1/4IN. DR. IS 3/8IN. DR.	10/20/2016	RJC	SM
3	17-0100	DELETED -5 MUST HAVE BLACK OXIDE FINISH NOTE. -1 ADDED ENGRAVE T/N, S/N, "MADE IN USA" NOTE. -1A CHD DIA WAS .620 IS .63. DELETED ENGRAVE T/N, S/N, "MADE IN USA" NOTE. -1C CHD DIA WAS Ø2.00 IS Ø2.00+-.00-.03.	4/24/2017	DPD	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168853 MWS
17-11-23



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
	X		-1	1	WELDMENT			2
	1		-1A		BASE	A36/1018/1020 HR		3
	1		-1B		RISER	4140/4142		4
	1		-1C		TOP	4140/4142		5
	1		-1D		RISER	4140/4142		6
			-2	1	WASHER	NYLON		7
	1	B/O	-3		SOCKET		1/4in. DR. 1/4in. X 6PT SNAP-ON IMTM8A	2
		B/O	-5	1	SOCKET		3/8in. DR. 1/4in. X 6pt (MSC #48725303)	1
		B/O	-7	1	BUTTON SOCKET HEAD CAP SCREW	STEEL	10-32 X 1 (MCMASTER-CARR #91255A273)	1
	1	B/O	-9		DOWEL PIN	STEEL	Ø1/8 X 11/16 (MCMASTER-CARR #98381A172)	2
	ASSY -1							

			
TITLE FIXTURE-HOLDING FUEL NOZZLE			
DWG NO. RB6897875			REV 3
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES $.XXX \pm .005$ $.XX \pm .01$ $X \pm .1$ FRACTIONS $\pm 1/8$ ANGLES $\pm 5^\circ$ SURFACES = $125^\circ/\sqrt{}$	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL ROLLS ROYCE	
SCALE 1:2	DATE 9/16/2009	SHEET 1 OF 7	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
WORK ORDER NON-CONFORMANCE / UPDATE FORM 301042-01-01 01/01/2018								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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OTHER : ☐																									